

Date: Monday, 28/04/2008 8:13:29 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET LOCATOR
Job Number	: 38812		
Estimate Number	: 11229		
P.O. Number	:	Part Number	: D23691
This Issue	: 28/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2369 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 36241	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 05/05/2008
Checked & Approved By	: <u>JLD 08.4.28</u>	Qty:	6 Um: Each
Comment	: Est Rev A Removed from 9 Digit 05-12-05 JLM Est Rev:B now water jet 07-12-11 DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 1.4217 sf(s)/Unit Total: 8.5302 sf(s)
 Material: 5052-H34 or H32 0.040" thick
 (M5052H32S.040)
 Batch: _____

IB 8-4-30

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2369
 Dwg Rev: A
 Prog Rev: A

IB 8-4-30

2-Deburr if necessary

IB 8-4-30

8
 (P10) →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-4-30

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

80864/30 x 8

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

5/1/28
 8/4/30 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2369-1 PAR #: NA Fault Category: Prod / Prod Ass ^{med & Small} NCR: Yes No DQA: D Date: 08/05/01
D350-616 QA: N/C Closed: D Date: 08/05/01

NCR: 38812		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/01	1	hole size are about 0.010" ex over nominal. R.C. Plates on water jet are starting to be worn out	08.04.01 for OSI 08/2	Parts are accepted. this one time only, * waiting on center beam to be Re Replaced *	B 8-4-30	08/04/30	08/04/01	08/04/30

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:29 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET LOCATOR

Job Number: 38812

Part Number: D23691

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/01 *JS*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-05-01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38812
Description: Deck Plate Locator Bracket		Part Number:	D2369-1
Inspection Dwg: D2369	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.501	*			
4.500	+/-0.010	4.508	*			
1.000	+/-0.010	.998	*			
5.709	+/-0.010	5.704	*			
37.996	+/-0.010	37.996	*			
38.297	+/-0.010	38.297	*			
5.000	+/-0.010	4.997	*			
4.451	+/-0.010	4.454	*			
0.549	+/-0.010	.545	*			
Ø0.191	+0.005/-0.000	.196	*			
Ø0.128	+0.005/-0.000	.130	*			
39.000	+/-0.010	39.000	*			
38.544	+/-0.010	38.544				

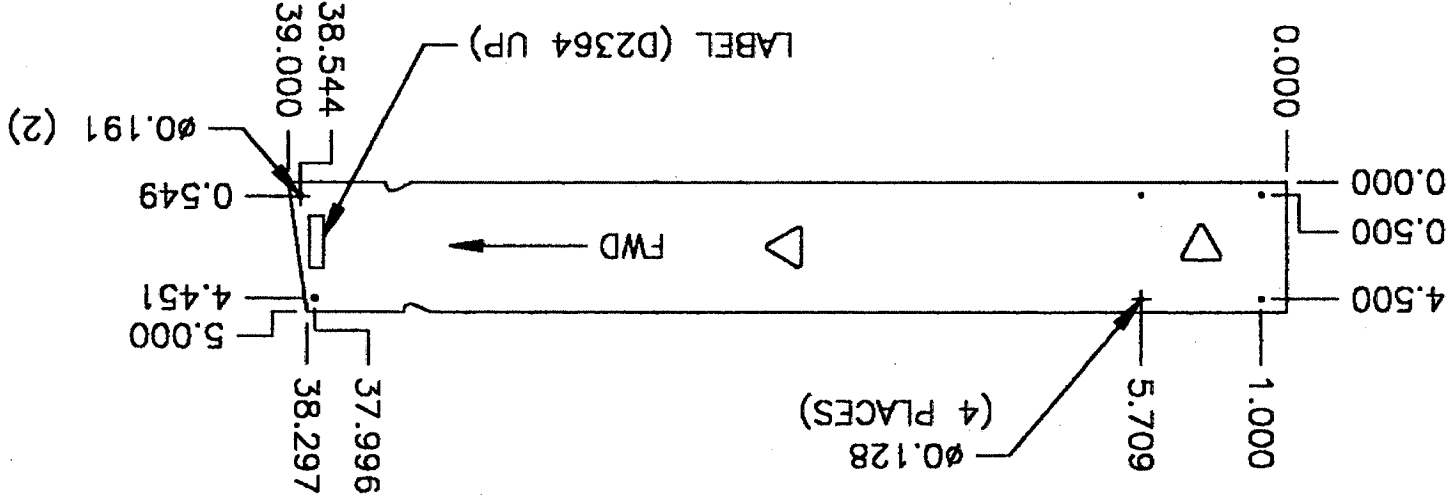
Measured by:	IB	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	8-4-30	Date:	8/4/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	[Signature]



DESIGN		DRAWN BY		DART AEROSPACE LTD	
B WILLIAMS		B WILLIAMS		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. A	
<i>[Signature]</i>	<i>[Signature]</i>	D2369		SHEET 1 OF 2	
DATE		TITLE		SCALE	
95:02:20		DECK PLATE LOCATOR BRACKET		1:1	

RELEASED
01 08 96



D2369-1

MATERIAL: 5052-H34 0.040 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 08812



RELEASED
960610